

Work Order ID 148792

July 08, 2016 10:34:06 AM

148792

Page 1

Item ID: PB67-43001-277

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Contoured Male Eye

Start Date: 7/8/2016 Start Qty: 1.00

Required Date: 8/3/2016 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: SH Date: 7/12/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001	C
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100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 1.250" x 1.250" x 2.250" long

0.00

0.00

5 16/07/17

5

0

DAS
08
9-89

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA544 and Dwg B67-43001

Identify as B67-43001-277

Dwg Rev 5

Folio Rev 5

Manually tap part as per Dwg B67-43001

Deburr

0.00

0.00

5

16-07-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclar ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

July 08, 2016 10:34:06 AM

Page 2

Reference:

Stop ***NR2***

Quality Control

Quality Control

Packaging

5 _____ 16-07-20

5 Ø

5 JUL 21 2016 DAS
8
2-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Page 3

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Accept

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Revision ID:

Stop ***NS2***

Item Name: Contoured Male Eye

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Required Date: 8/3/2016 Req'd Qty: 1.00 ***1***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC21- Final Inspection - Work Order Release

0.00

150

DAS

21

9-89

JUL 22 2016

QC

Memo

0.00

Quality Control

DAS

21

9-89

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

July 08, 2016 10:34:05 AM

Page 1

Work Order ID: 148792

148792

Parent Item: PB67-43001-277

PB67-43001-277

Parent Item Name: Contoured Male Eye

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.07.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased		No		100	f	10.5280	0.1875	0.197368			

M6061T6B1 250X01 250

6061-T6 Bar 1.25 x 1.25

B. 12/07/17

DAS
08
9-89

Location

Loc Qty

Loc Code

MAT003

10.528

m126647

0.246

m133699

0.702

→ m134776

9.58

0.9583

DQA: _____ Date: _____

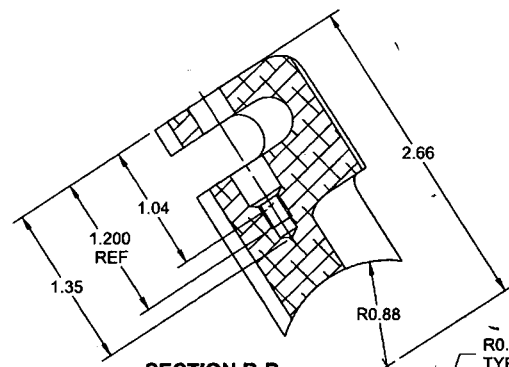


WORK ORDER NON-CONFORMANCE / UPDATE

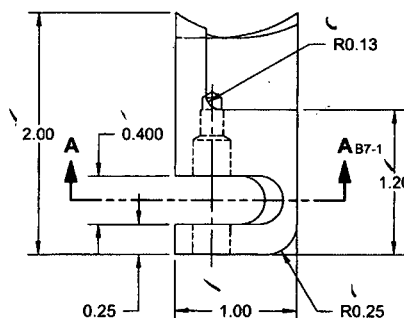
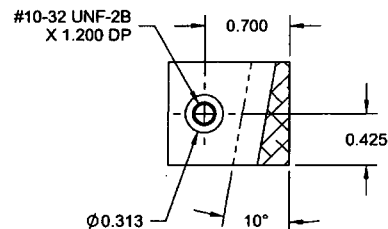
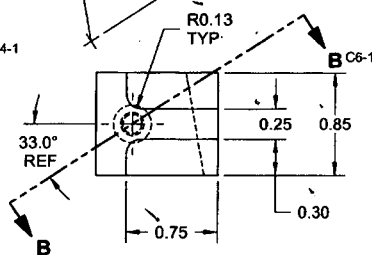
QA Closed: _____ Date: _____

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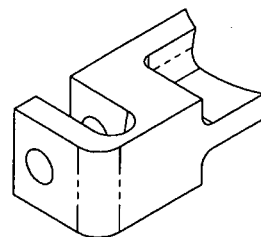
SECTION B-B C4-1



B67-43001-277 CONTOURED MALE EYE

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs



RELEASED
2009-09-24

SH 148792 7/12/16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 20 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	ASS	DRAWING NO. B67-43001-277	REV. C	
MFG. APPR.			SHEET 1 OF 1	
APPROVED	AMG	TITLE	SCALE	
DE APPR.	N/A	CONTOURED MALE EYE	NTS	
DATE	09.02.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT		

DART AEROSPACE LTD		Work Order:	148 792
Description: Contoured Male Eye		Part Number:	B67-43001-277
Inspection Dwg: B67-43001-277 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.66	+/-0.030	2.668	✓		Vern	
1.35	+/-0.030	1.325	✓			
R0.13	+/-0.030	.125	✓			
0.25	+/-0.030	.250	✓			
0.85	+/-0.030	.849	✓			
0.30	+/-0.030	.300	✓			
0.75	+/-0.030	.747	✓			
10-32 UNF-2B	N/A	10-32unf	✓		gonogogage	
x 1.200 Deep	+/-0.010	1.210	✓		Vern	
0.700	+/-0.010	.699	✓			
Ø0.313	+0.006/-0.001	.313	✓		gage pin	
0.425	+/-0.010	.424	✓		Vern	
2.00	+/-0.030	1.985	✓			
0.400	+/-0.010	.399	✓			
0.25	+/-0.030	.250	✓			
1.00	+/-0.030	1.004	✓			
R0.25	+/-0.030	.250	✓			
0.110 Slot	Ref	.117	✓			
0.260 Slot	Ref	.267	✓			

Measured by:	<i>[Signature]</i>	Audited by:	DAS 44 9-89	Preliminary Approval:	
Date:	16-07-20	Date:	16-07-20	Date:	

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM	
B	08.09.09	1.30 dimension added	KJ/DD	
C	10.10.08	Dimensions updated per Dwg Rev C	KJ	
D	12.10.29	Dimensions updated	KJ <i>[Signature]</i>	<i>[Signature]</i>